



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9713

Job Sheet 177118



Part No: 646.9713

Job Qty: 6 ea

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/7/18

Job Tracking No:

Due Date: 5/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D2 SHEETS 1-4, 7 IPP Rev.A New issue JFS 16/03/08 Verify by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/11/18	0.00	0.00	Start Up Machining-1		<i>W</i>
100	Bandsaw	6 pcs		5/11/18	0.00	1.03	Bandsaw1		<i>W</i>
110	CNC Vertical Machining	6 pcs		5/11/18	0.60	8.82	HAAS1-1		<i>W</i>
120	QC	6 pcs		5/11/18	0.00	0.00	QC2 Machining-1		<i>W</i>
130	QC	6 pcs		5/11/18	0.00	0.00	QC8 Machining-1		<i>W</i>
140	Outsource	6 pcs		5/11/18			ATG001-VC	5	<i>W</i>
150	Packaging	6 pcs		5/11/18	0.00	0.00	Packaging2		<i>W</i>
155	QC	6 pcs		5/11/18	0.00	0.00	QC5		<i>W</i>
180	Packaging	6 pcs		5/11/18	0.00	0.00	Packaging3-1		<i>W</i>
190	QC21-SA	6 Ea		5/11/18	0.00	0.00	QC21		<i>W</i>

Part Op 100 - Cut Blank at 7.425"

Descriptions: 110 - 1-Machine per folio FB464

140 - Issue P/O to ATG : *PO 505050* Anodize, Color Black, Prime as per Dwg 646.9700

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

3.75 pied

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B5.000X1.000	7075-T6 Bar 5.000" X 1.000"	3.7200 ft (.62 ea)	90-Start up Operation	<i>504630</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B5.000X1.000	4	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.487Inches ± 0.005	0.492 0.482		
2	Body	4.784Inches ± 0.002	4.786 4.782		
3	Body	3.603Inches ± 0.002	3.605 3.601		

Plex 5/7/18 9:10 AM Dart.Gagnon.Michelle

5/7/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

4	Body	2.422Inches ± 0.002	2.424 2.420
5	Body	1.400Inches ± 0.002	1.402 1.398
6	Body	0.375Inches ± 0.002	0.377 0.373
7	Body	0.409Inches ± 0.002	0.411 0.407
8	Body	0.350Inches + 0.005 - 0.000	0.355 0.350
9	Body	0.875Inches ± 0.005	0.880 0.870
10	Body	1.067Inches ± 0.002	1.069 1.065
11	Body	2.608Inches ± 0.002	2.610 2.606
12	Body	 Container No: S090043  Part: 646.9713 Job No: 177118 Serial No/Batch: S090043 Revision: E Inspector: Exp Date: Instructions:	
13	Body		
14	Body		
15	Body		
16	Body		
17	Body		
18	Body		
19	Body		
20	Body		
21	Body		
22	Body		
23	Body		
24	Body		
25	Body		
26	Body		
27	Body		
28	Body		
29	Body		
30	Body		
31	Body		0.695
32	Body	5.500Inches ± 0.005	5.505 5.495
33	Body	6.8Angle ± 0.5	7.3 6.3

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/09/18

Plex 5/7/18 9:10 AM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order:	Apprentice
Description: Body	Part Number:	646.9713
Inspection Dwg: 646.9700 Rev: D2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.487	+/-0.005	.487	✓			
4.784	+/-0.002	4.782	✓		high gage	
3.603	+/-0.002	3.602	✓		high gage	
2.422	+/-0.002	2.421	✓		high gage	
1.400	+/-0.002	1.399	✓		high gage	
0.375	+/-0.002	.3745	✓		high gage	
0.409	+/-0.002	.409	✓		Verrier high gage	
0.350	+0.005/-0.000	.352	✓		Pin gage	
0.875	+/-0.005	.879	✓			
1.067	+/-0.002	1.067	✓			
2.608	+/-0.002	2.608	✓			
2.750	+/-0.002	2.750	✓			
2.892	+/-0.002	2.892	✓			
3.348	+/-0.002	3.348	✓			
3.597	+/-0.002	3.597	✓			
3.847	+/-0.002	3.847	✓			
0.544	+/-0.002	0.544	✓			
2.195	+/-0.002	2.195	✓			
3.395	+/-0.002	3.395	✓			
3.495	+/-0.002	3.495	✓			
4.595	+/-0.002	4.595	✓			
4.687	+/-0.002	4.687	✓			
4.734	+/-0.002	4.734	✓			
Ø0.177	+0.005/-0.001	.177 Ø	✓		Pin gage	
Ø0.201	+0.005/-0.001	.202 Ø	✓		Pin gage	
0.13 x 45°	+/-0.010 x +/-0.5°	.130 x 45°	✓		Verrier	
1.500	+/-0.005	1.498	✓		Verrier	
0.660	+/-0.005	.658	✓		high gage	
0.660	+/-0.005	.660	✓		high gage	
0.700	+/-0.005	.702	✓		Verrier	
5.500	+/-0.005	5.498	✓		Verrier	
6.8°	+/-0.5°	6.8°	✓		Gaborit	

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	16.04.05	New Issue	KJ	
B	16.11.24	Dimensions revised	KJ 	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040504**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040504
PO Date: 7/16/18
Due Date: 7/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179153	646.3210	Support Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	7/23/18	12 pcs	0 pcs	12 pcs	\$17.15/pcs	\$205.80
2	177118	646.9713	Body Issue P/O to ATG : Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	7/23/18	6 pcs	0 pcs	6 pcs	\$17.30/pcs	\$103.80
3	179167	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	7/23/18	24 pcs	0 pcs	24 pcs	\$9.40/pcs	\$225.60
4	176394	RBW1205G00231-3G-1	Body -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	7/20/18	12 pcs	0 pcs	12 pcs	\$13.21/pcs	\$158.52
Grand Total:											\$693.72

Order Notes

CT.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915626

Date: 23-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity		Description	
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
6 ea	Part: 646.9713 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0013" (.6 - .9 mils) per drawing. Job: 23452	Rev: D	PO: PO040504
Line:			
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>23/07/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

DAS
38
9-89

Made in Canada.